

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000015**Date Inspected:** 03-Nov-2006**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe:**Fracture Critical****Index Lot #:** B72-048-06A**Witness Lot #:** B72-048-06**Bridge No:** 34-0006**Component:** N/A**Welder:** Lei Li Chao**ID #:** 053619**Joint Description:** Single V/w Backing

N/A

WPS ID #: PWPS B-T-2231FB

N/A

Base Metal: A709M 345

N/A

PQR ID #: HP-2006104 (Min)

N/A

Thickness: 26mm

N/A

Process: FCAW

N/A

Electrode Spec/Class: A5.20/E71T-1

N/A

Positions: 1G

N/A

Backing Material: A709M

N/A

CWI: Liu Liu

N/A

Average Amps: 301.2

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts: 31.2

N/A

Applicable Sec: 5.12 Min & 12

N/A

Travel Speed: 381.6mm/min

N/A

Heat Input: 1.48kilojoules/mm

N/A

Preheat: 39.1C

N/A

Summary of Items Observed:

This was a figure 5.1 test plate for testing weld mechanical properties using the flux cored arc welding to paragraph 5.12 for Minimum Heat Input settings.

Summary of Conversations:

A conversation was held between Craig A. Knops of Flour and Mr. Liu of ZPMC concerning the angle of the flux-cored electrode feed. Mr. Knops felt that ZPMC should have more of an angle toward the edge of the weld for the split pass. Mr. Liu eventually agreed and the angle was changed and welding continued.

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is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Lowry,Patrick

QA Reviewer